



CEWELD SA 309LMo strip

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding strip										
TOEPASSINGEN	Boilers, chemical industry components, offshore industry										
EIGENSCHAPPEN	SA 309LMo strip is stainless steel strip for cladding overlay applications. Latest generation clean melting quality guarantees optimum metallurgical quality and attractive weld appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes. Cladding on low alloyed steels in case a 18/8/2 (AISI 316) CrNiMo layer is required in the first layer.										
CLASSIFICATIE	AWS A 5.9: EQ309LMo EN ISO 14343-A: B 23 12 2 L W.Nr. 1.4459										
GESCHIKT VOOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306, X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444 S31640, S31603, S31653, S31600, S31630, S44400										
GOEDKEURINGEN	CE										
LASPOSITIONS											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo			
	0.015	0.3	1.8	0.02	0.02	24	13	2.5			
MECHANISCHE WAARDEN	Heat Treatment		R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Hardness					
	As Welded		450	600	>30	HRc					
HERDROGEN	Not required										
GAS ACC. EN ISO 14175											